

Work Order ID 163383

163383

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Tuesday, June 27, 2017 11:35:28 AM

Item ID: D4770-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar Weldment
 Start Date: 6/29/2017 Start Qty: 2.00 *7* 400
 Required Date: 7/10/2017 Req'd Qty: 2.00 *3*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: DAS 21 9-29 Date: JUL 03 2017 Tooling: Date: Run Start *NR1*
 QC: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4770	C								
100		0.00							
100									
Cold Saw	Memo	0.10							
Hyd Mech	1- CUT D4770-5 BLANKS AT 56.25"								
110	Weld per dwg & QSI004 4.5	0.00							
110									
autoweld 1	Memo	0.60							
Automated Welding 1	***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- USE GRINDER TO CHAMFER END AS PER DWG. FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M13576								

4 Q.L 17-07-12

4 Q.L 17-08-11

Work Order ID 163383***163383***

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Tuesday, June 27, 2017 11:35:28 AM

Item ID: D4770-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar Weldment
Start Date: 6/29/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/10/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
150									
QC	Memo	0.20							AUG 2 1 2017
Quality Control									

DAS
21
9-89

AUG 15 2017

Picklist Print

Page 1

Tuesday, June 27, 2017 11:35:25 AM

Work Order ID: 163383

163383

Parent Item: D4770-045

D4770-045

Parent Item Name: Bar Weldment

Start Date: 6/29/2017

Required Date: 7/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 17.04.17 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.250x0.500

Purchased

No

100

f

126.5780

4.69

9.873684

M304B0 250x0.500

304 BAR .250 x .500

JUL 11 2017

**

Q.L 17-08-11

Location

Loc Qty

Loc Code

WA002

126.578

~~m137512~~

22.57

m137065

13.2

m137172

6.808

~~m137824~~

84

D4770-S

X4

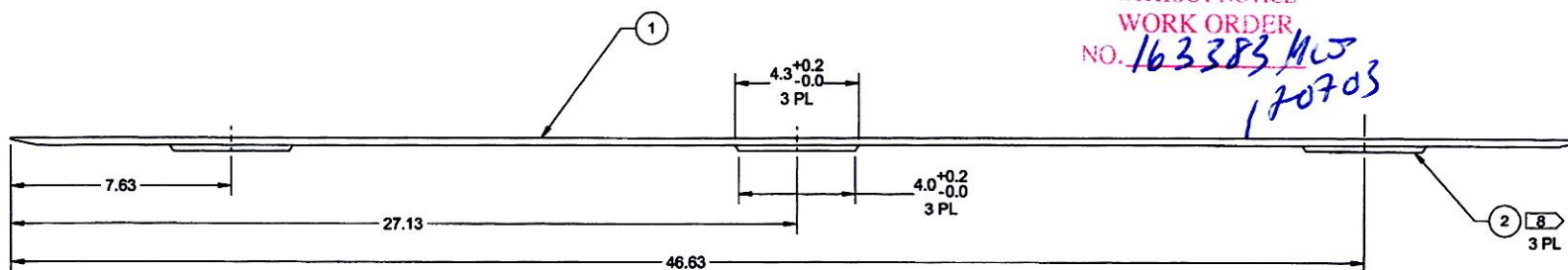
B:

146921

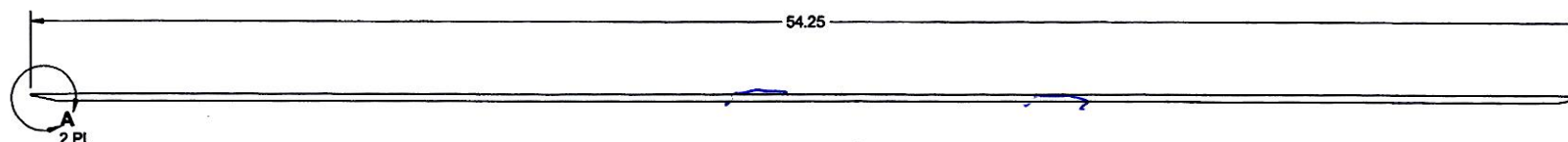
Q.L

ITEM	QTY	P/N	DESCRIPTION
	X	D4770-045	BAR WELDMENT
1	1	D4770-5	BAR
2	A/R	8259/2059B	HARD SURFACING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163383 MWS
170703



D4770-045 BAR WELDMENT $\triangle$



D4770-5 BAR $\triangle$

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 2.28 lbs

$\triangle$ 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED

2017 APR 10

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	SAD	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4770	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	D9	BAR	NTS
DATE	17.02.14	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>163383</u> Part No. <u>D4770-045</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐																																																	
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Description Work Order Deviation				Disposition																																																																			
PARTS IN STOCK ARE MADE TO D4770 Rev.B				Acceptable to make parts to D4770 Rev.B. Changes in Rev.C were to facilitate production.																																																																			
				Completed By DAS 12 9-89 <u>17/7/11</u>																																																																			
				Lead hand / Supervisor Approval Verification DAS 38 9-89 <u>AUG 25 2017</u>																																																																			
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